

Date: Thursday, 7/13/2006 3:38:06 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|-------------------------------------|------------------|---------------|
| Customer | CU-DAR001 Dart Helicopters Services | Drawing Name | : TUBE |
| Job Number | : 27899 | | |
| Estimate Number | : 11175 | | |
| P.O. Number | : N/A | Part Number | : D22825 |
| This Issue | : 7/13/2006 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : D2282 REV E |
| First Issue | : N/A | Project Number | : N/A |
| Previous Run | : 26816 | Drawing Revision | : E |
| Written By | : | Material | : N/A |
| Checked & Approved By | : | Due Date | : 8/15/2006 |
| Comment | : Est Rev:A | Qty: | 100 |
| | Removed from 9 Digit | Um: | Each |
| 05-12-02 JLM | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---|
| 1.0 | M304R0750 | Inventory |
| | | |
| | | Comment: Qty.: 0.1891 f(s)/Unit Total : 18.9063 f(s) Material: AISI 304 Stainless Steel Ø0.750(M304R0.750) Batch <u>M103085</u> J.G 06/09/15 |
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
| | | |
| | | Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA189 2-Deburr J.G 06/09/15 |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.G 06.09.16 100 |
| 4.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
| | | |
| | | Comment: HAAS #1 HAAS #1 J.F. 06/11/01 100 |
| 5.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 06/11/01 100 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

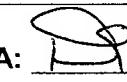
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/11/01

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 7/13/2006 3:38:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 27899

Part Number: D22825

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 06/11/01

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST35

Box/Job 100

8.0 DC DOCUMENT CONTROL



(100)

Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/11/01

Job Completion



C Level 11/101

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

| | | |
|------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 27899 |
| Description: Handle Tube | Part Number: | D2282-5 |
| Inspection Dwg: D2282 Rev: E | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

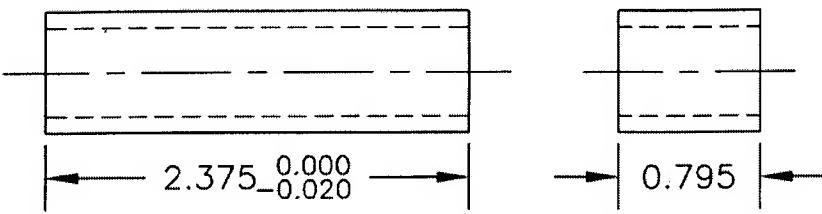
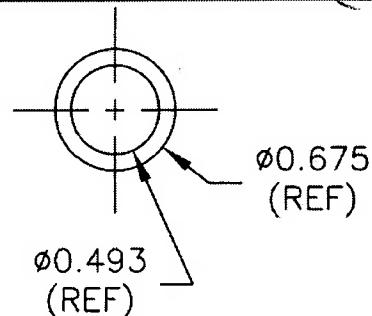
| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | Ba/J.F. | Audited by: | J.G | Prototype Approval: | N/A |
| Date: | 06/10/31 | Date: | 06/10/31 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|------------|-------------|---|-------------------|-----------------|
| A | 03.11.11 | New Issue P/O D350-615-041 | KJ/RF | |
| B | 05.04.19 | Dimensions & tolerances changed | KJ/JLM | |
| C | 06.03.15 | Dimensions & tolerances revised per Dwg Rev E | KJ/JLM | ✓ ✓ |

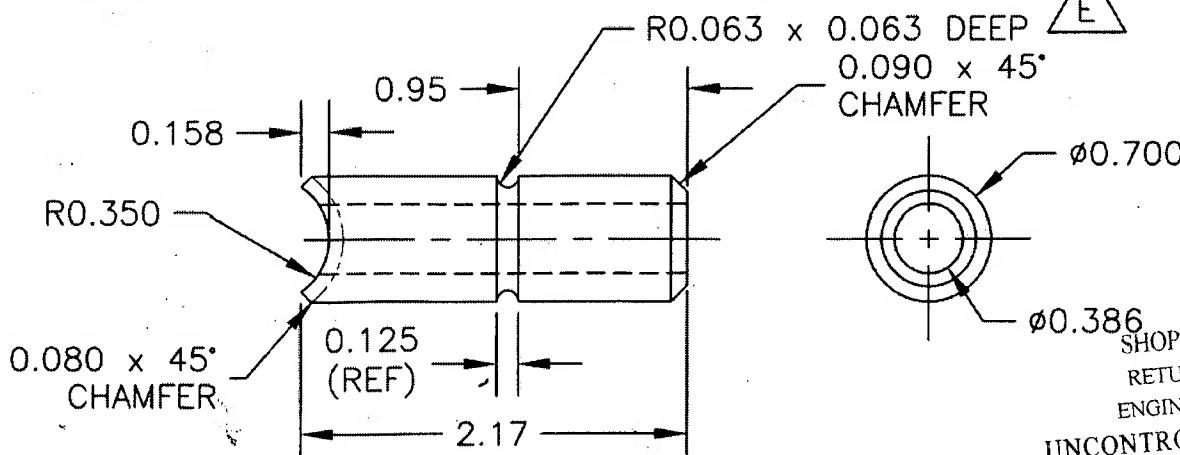
DART

| | | |
|------------------------------|--------------------------------|---|
| DESIGN BW | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>[Initials]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2282 |
| DATE 05.06.07 | TITLE HANDLE TUBES | REV. E SHEET 1 OF 2 SCALE 1:1 |

RELEASED
[Handwritten signature]
BS/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

E

Ø0.700

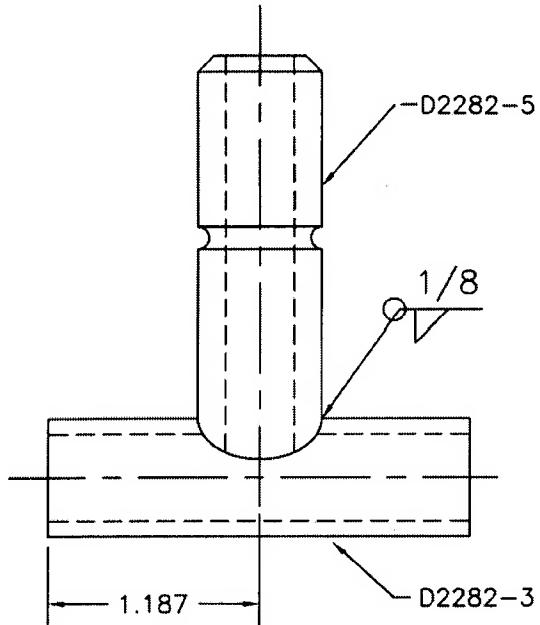
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NO. 27899

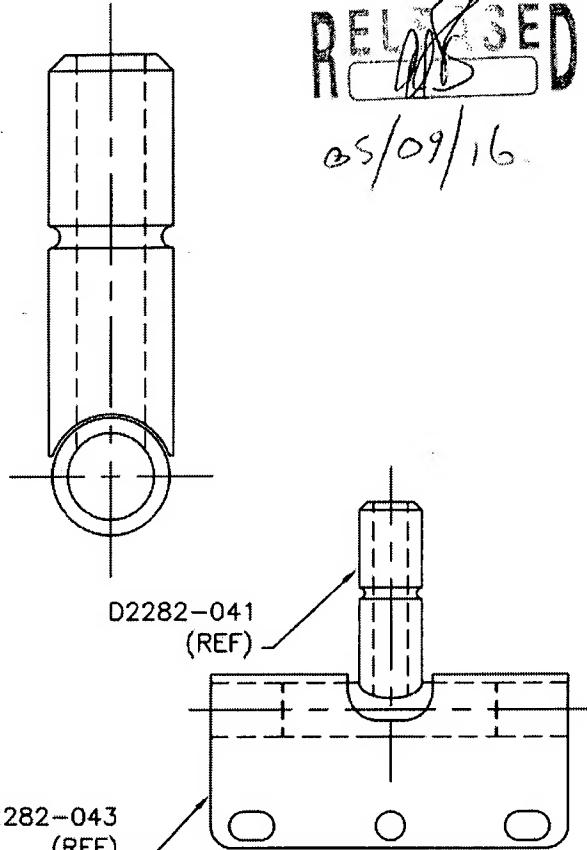
E

DART

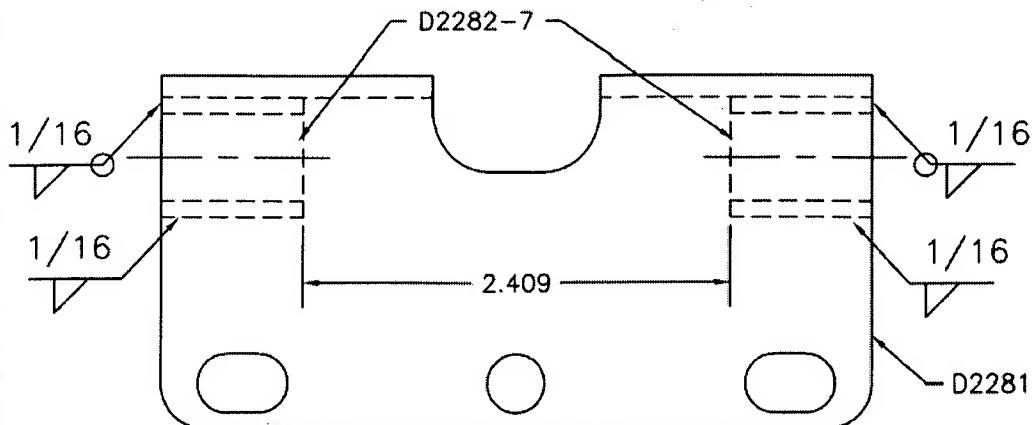
| | | |
|----------------------|------------------------|---|
| DESIGN BW | DRAWN BY <i>RF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>UP</i> | APPROVED <i>MBS</i> | DRAWING NO. D2282 |
| DATE 05.06.07 | | REV. E SHEET 2 OF 2 TITLE HANDLE TUBES SCALE 1:1 |



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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